

Work Order ID 148742

Wednesday, July 06, 2016 8:46:20 AM

148742

Page 1

Item ID: D3558-9

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket Fwd

Start Date: 7/4/2016 Start Qty: 8.00 ***8***

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 8.00 ***8***

Customer:

Reference:

Approvals: Process Plan: **DAS** Date: **JUL 11 2016** Tooling: _____ Date: _____
QC: **21** Date: _____ SPC (Y/N): _____ Date: _____
9-89

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3558	Rev B								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.09

FLOW CNC Waterjet

1-Cut as per Dwg D3558 Dwg Rev: **B** Prog Rev: **B** 2-
Deburr if necessary

(16)

DE 16/07/27

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

(16)

DE 16/07/27

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.03

Quality Control

(16)

**DAS
38
9-89**

JUL 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 148742

Wednesday, July 06, 2016 8:46:20 AM

148742

Page 2

Item ID: D3558-9

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket Fwd

Start Date: 7/4/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: FP-00

0.00

130

Packaging

Memo

0.01

Packaging

LOCATION : FP001

x16 d Jll 16/07/2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.13

Quality Control

HJ / RW 16/07/2016

DAS
21
9-89

JUL 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval					
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY											
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER :											

Picklist Print

Wednesday, July 06, 2016 8:46:19 AM

Page 1

Work Order ID: 148742

148742

Parent Item: D3558-9

D3558-9

Parent Item Name: Gasket Fwd

Start Date: 7/4/2016

Required Date: 7/5/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev B dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	195.4000	0.44	3.911111			

MNEO60S 063

NEOPRENE SHEET 0.063

Dr 11/2/07/27

Location

Loc Qty

Loc Code

MAT052

195.4

M133744

11

M134972

184.4

7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

DART AEROSPACE LTD		Work Order: 148742
Description: Gasket		Part Number: D3558-9
Inspection Dwg: D3558 Rev: B		Page 1 of 1

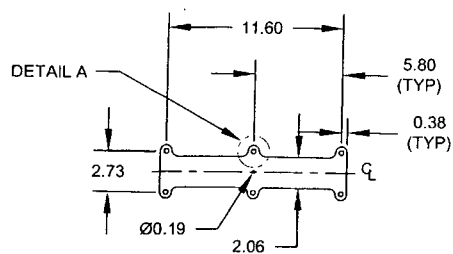
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

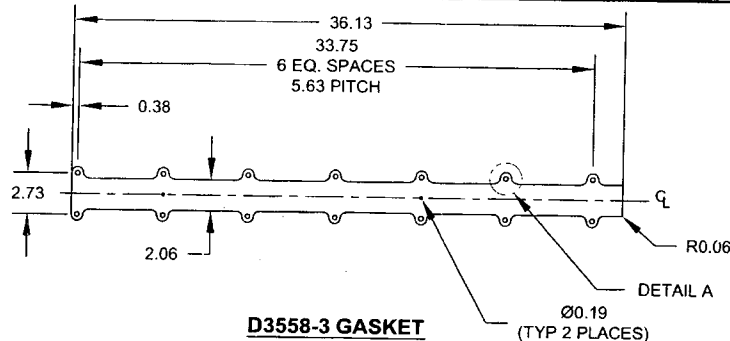
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	Ø .19	/		Tape	
0.30	+/-0.030	.30	/			
0.30	+/-0.030	.30	/			
0.38	+/-0.030	.38	/			
2.06	+/-0.030	2.06	/			
2.73	+/-0.030	2.73	/			
2.90	+/-0.030	2.90	/			
5.80	+/-0.030	5.80	/			
11.60	+/-0.030	11.60	/			
17.40	+/-0.030	17.40	/			

Measured by: <u>De</u>	Audited by: <u>38</u>	Prototype Approval:	N/A
Date: <u>16/07/27</u>	Date: <u>16/07/27</u>	Date:	N/A

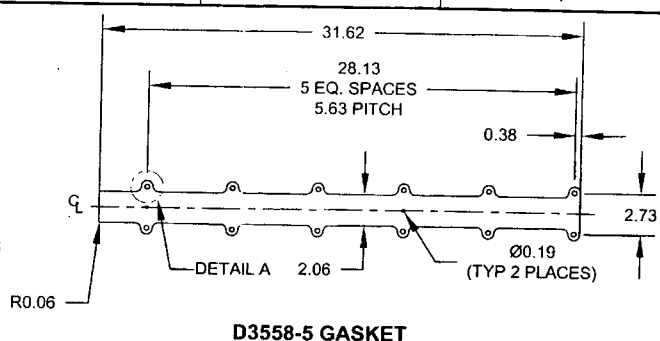
Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	<u>[Signature]</u>



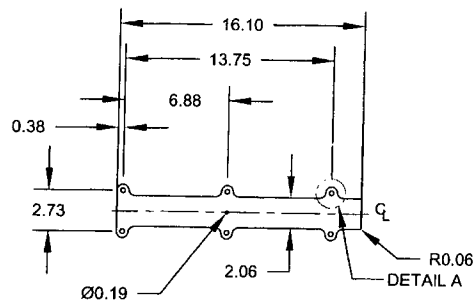
D3558-1 GASKET



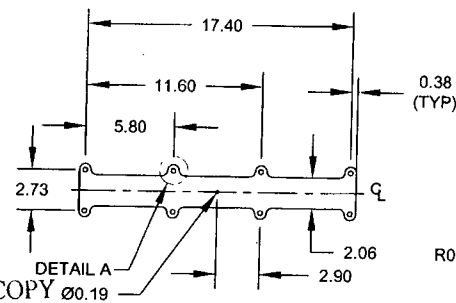
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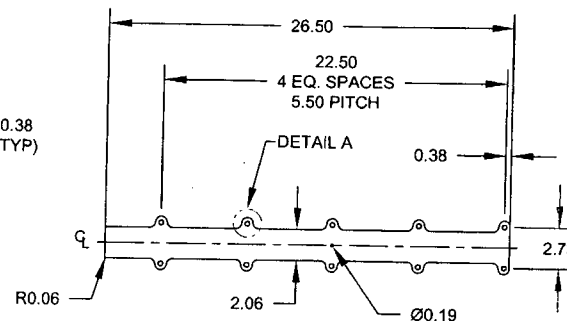
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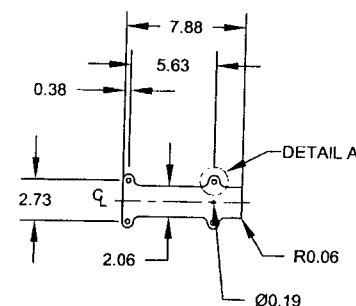
D3558-7 GASKET



D3558-9 GASKET

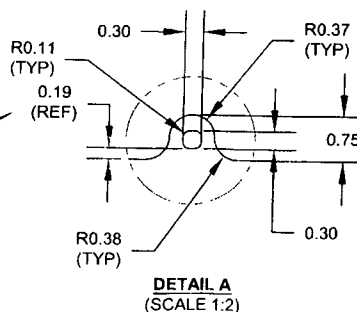


D3558-11 GASKET



D3558-13 GASKET

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148742 MCG
16-0718



DETAIL A
(SCALE 1:2)

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF. DART SPEC. M-NEW60-S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3558-1 - 0.09 lbs, D3558-3 - 0.26 lbs, D3558-5 - 0.23 lbs, D3558-7 - 0.12 lbs, D3558-9 - 0.13 lbs, D3558-11 - 0.19 lbs, D3558-13 - 0.06 lbs

RELEASED
07/11/16

B	ADD -9/11-13; UPDATE DRAWING FORMAT	PH	07.04.20
A	NEW ISSUE	PH	06.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	D3558		
APPROVED	TITLE		
DE APPR.	GASKET	SCALE	1:
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	